

13 MARS

Work Order ID 157432

157432

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Wednesday, February 22, 2017 9:03:08 AM

Item ID: D2563 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Weldment Assembly
 Start Date: 3/6/2017 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 3/13/2017 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan:  Date: FEB 22 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2563	Rev C								

100

100

Large Fab

Large Fab

Large Fab

Memo

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

← 3x DG 2017/03/02

0.00

0.28

17-2-24(3)

7 BE 17-2-28

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

③ 17-03-06

DAS
9
9-89

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3 17.3.6 Cpl

DAS
9
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Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 3/13/2017 Req'd Qty: 3.00 ***3*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>B134785</u> Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind	0.00 0.28							
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01							

3x CL 17-3-8

(3) 17-03-09 DAS 9 9-89

(3) 17-03-09 DAS 9 9-89

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NS1

Stop *NS2*

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Touch up Alodine as per QSI005

Memo

Hand Finishing

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Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment Assembly
Start Date: 3/6/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 3/13/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
200						3			DAS 38 9-89
QC	Memo	0.01							MAR 20 2017
Quality Control									
210	Identify as per dwg & Stock Location: _____	0.00							
210						3			DAS 28 9-89
Packaging	Memo	0.01							MAR 21 2017
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.05							17/3/21
Quality Control									

DAS
21
9-89MAR 21 2017
MAR 21 2017

Picklist Print

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Work Order ID: 157432

157432

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 3/6/2017

Required Date: 3/13/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2244-116		Manufactured	No			100	Each	94.0000	1	3			
D2244-116									**			17-2-24	
Step Extrusion													

Location	Loc Qty	Loc Code
WA003	94	
150064	94	
xxxxx	0.0000368	

D2561		Manufactured	No			100	Each	14.0000	2	6			
D2561									**			17-2-24	
Lug													

Location	Loc Qty	Loc Code
WA003	14	
156145	14	

D2564		Manufactured	No			100	Each	19.0000	2	6			
D2564									**			17-2-24	
Mounting Angle													

Location	Loc Qty	Loc Code
WA003	19	
152795	19	

D2673-34		Manufactured	No			100	Each	28.0000	1	3			
D2673-34									**			17-2-24	
End Plate													

Location	Loc Qty	Loc Code
WA003	28	
151793	2	
152320	24	
155298	2	

Picklist Print

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Work Order ID: 157432

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Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 3/6/2017

Required Date: 3/13/2017

Start Qty: 3.00

Required Qty: 3.00

D2673-34

Manufactured

No

150

Each

28.0000

1

3

MAR 20 2017

DAS
24
9-89

D2673-34

End Plate

Location

Loc Qty

Loc Code

WA003

28

151793

2

152320

24

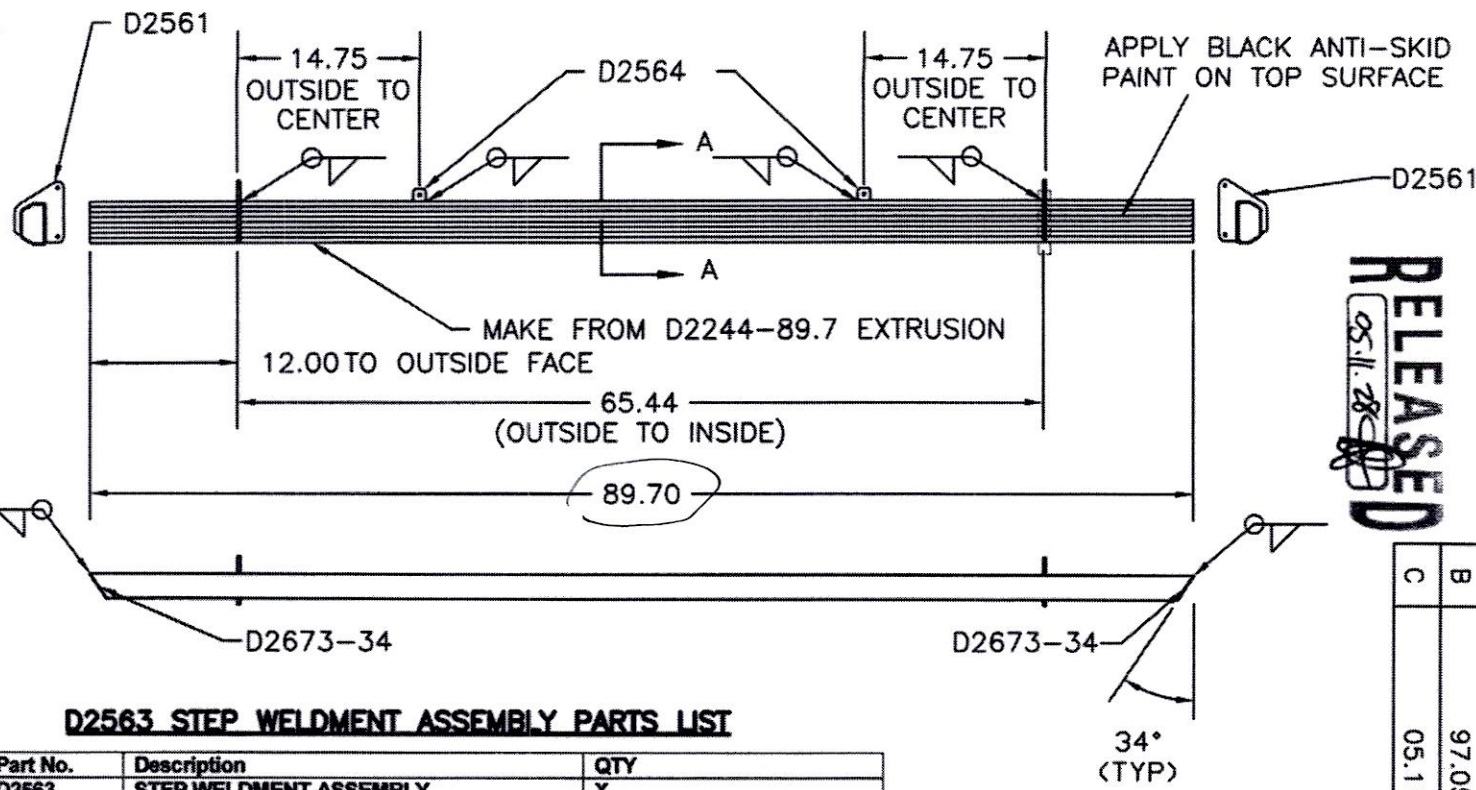
155298

2



RELEASED
05.11.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		H		HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. C
				D2563	SHEET 1 OF 1
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY	SCALE	1:15
A	96.04.26	NEW ISSUE			
B	97.05.14	END CAPS CHANGED (WAS D2248)			
C	05.11.14	UPDATE NOTES			



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157432 MP

FEB 22 2017

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>157432</u> Part No. <u>D2563</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☒</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : <u>17/3/16</u>		Step #: <u>180</u>		QTY Effective : <u>3</u>		MRB (QSI042) Approval <u>DAS</u> <u>12</u> <u>9-89</u>																			
Description Work Order Deviation				Disposition		Completed By																			
Powder coat oven is broken.				Acceptable to prime/paint white per QSI 005 4.2 Ref. ICA-D205-633 Rev. 2, 5.2.3		<u>17/3/16</u>																			
						Lead hand / Supervisor Approval Verification																			
						QC / QA Coordinator Approval																			
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			